

Date: Monday, 2/5/2007 3:46:29 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOOR ASSEMBLY	
Job Number	30640		Part Number	D3213041	
Estimate Number	10713		Drawing Number	D3213 REV A	
P.O. Number	N/A		Project Number	N/A	
This Issue	2/5/2007	S.O. No.	N/A	Drawing Revision	A
Prsht Rev.	NC	Type	SMALL /MED FAB	Material	N/A
First Issue	N/A			Due Date	2/15/2007
Previous Run	25254			Qty:	4
Written By			Um:	Each	
Checked & Approved By	FJ 0702.05				
Comment	Est Rev:A New Issue 05-11-17 17:27				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2	D3161-3	Hinge	B19672 X7
			B23189X1

PTO

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Can not scan

Pick: Assembly Kit

Qty Part Number Description Batch

1	D3213-1	Door	B30656 x4
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3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Can Not Scan

Pick: Assembly Kit

Qty Part Number Description Batch

1	D3213-3	Door	B30657 B30657 x4
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4.0	MS20470AD44	Rivet, Universal Head
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✓

Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

24	MS20470AD4-4	Rivet	M18729 x96
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ml07/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/20	1	Found one D3161-3 To Short (14.800") of Batch B 23189 Scrapone Holes don't match	QSI042	Scrap Two D 3161-3 replace by new one B23189	ml 07/02/20	07/02/26	QSI042	07/02/26
				A new jig for door assy will be appreciate!	ml 07/02/20			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOOR ASSEMBLY	
Job Number: 30640		Part Number: D3213041	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1		x4	<i>ml 07/02/21</i>
1-Assemble as per Dwg D3213 Identify as D3213-041			<i>ml 07/02/21</i>
6.0	QC5 	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP		<i>ml 07/03/02</i>	4
7.0	POWDER COATING 	POWDER COATING	
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		<i>ml 07/03/02</i>	07-03-07(4)
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		FF	07-03-09
9.0	D2137 	Decal - No Step	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2137 Decal <i>B24358</i>		FF	07-03-09
10.0	D2419 	Handle	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2419 Handle <i>R28202</i>		FF	07-03-09
11.0	D2462 	Neoprene Seal	
Comment: Qty.: 2.4000 f(s)/Unit Total : 9.6000 f(s) Pick: Assembly Kit Qty Part Number Description Batch 2 D2462 Seal <i>B29456</i>		FF	07-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

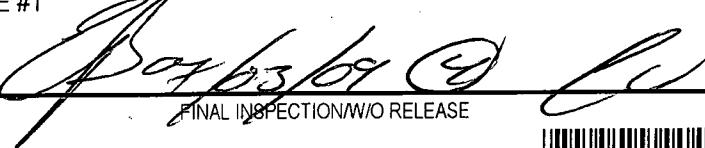
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/26	S.O	4x3161-3 SCRAP. The original drill gig to do the holes that get riveted onto the D3210-1, was not very good. Holes were oval, oversized, causing major hole mis-alignment between the two parts. → <input checked="" type="checkbox"/>	AS1042	Scrap. Replace the top hinge. use new drill gig D18470 to do top holes as per Dwg.		07/03/12	AS1042	07/02/26
				Take out 28 rivets Scrap 4 hinges 1/2" replace them by new one D3161-3 B30652 ✓	01/02/27			
				MS 20470 AD 4-4 M103044 ✓				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOOR ASSEMBLY
Job Number: 30640		Part Number: D3213041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	D27281	Dart Logo label small 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 2 D2728-1 Decal <u>B24215</u>		FF 07-03-09 4
13.0	AN960JD6	Washer 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 AN960JD6 Washer <u>M6085</u>		FF 07-03-09 4
14.0	MS20470AD46	Rivet, Universal Head 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 MS20470AD4-6 Rivet <u>M18615</u>		FF 07-03-09 4
15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3213		FF 07-03-09 4
16.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		07/03/09 (4)
17.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
18.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07/03/10 (4)
Job Completion 		07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NO

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 30640

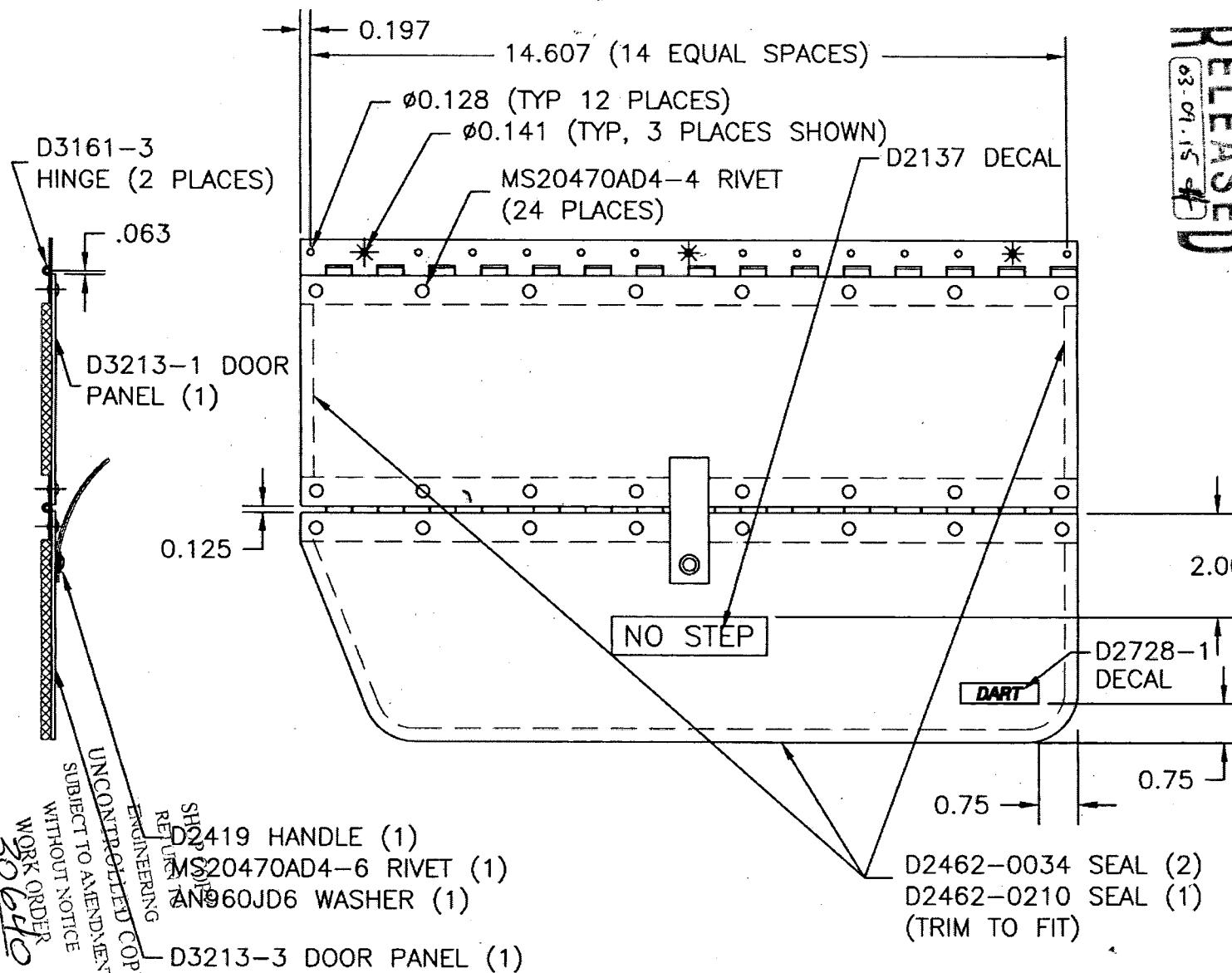
D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
03-09-03

DART

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2003

DESIGN	DRAWN BY	DART AEROSPACE LTD
A	D	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3213
DATE		TITLE
03.09.03		DOOR ASSEMBLY
A	03.09.03	NEW ISSUE

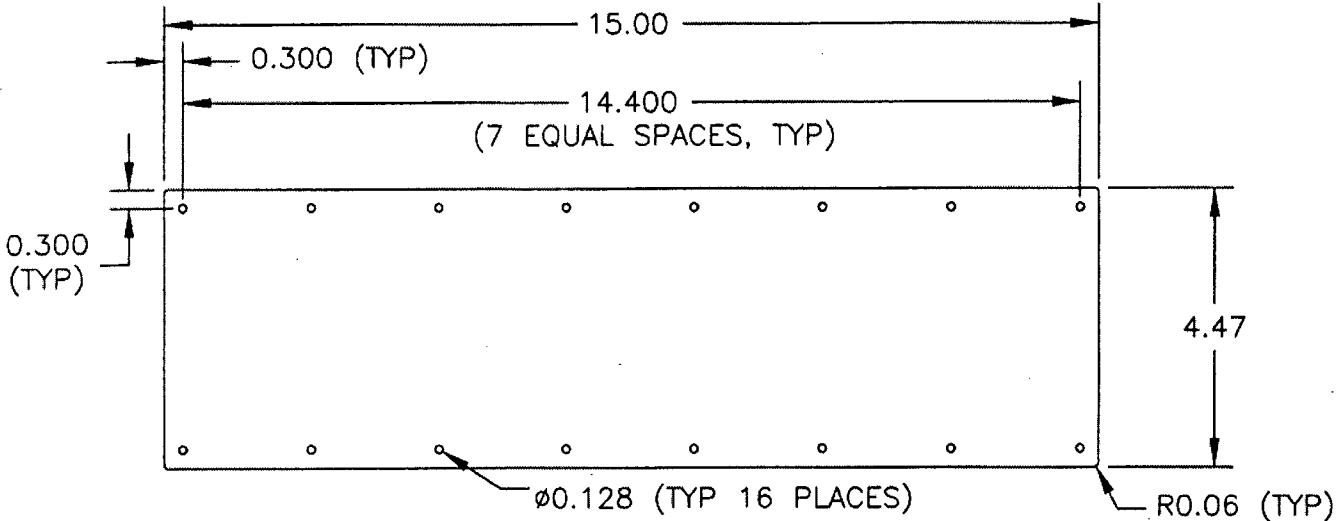
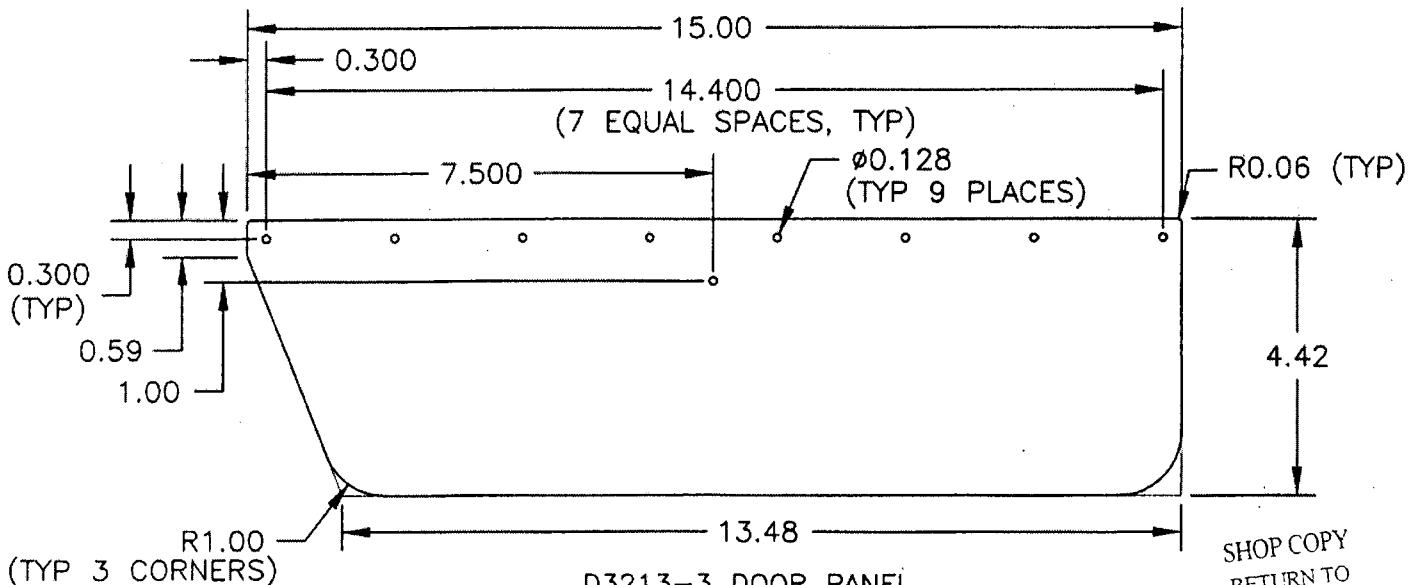
REV. A
1 OF 2
SCALE
1:3

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE	TITLE	SCALE 1:3

REV. A
2 OF 2

03.09.03 DOOR ASSEMBLY

D3213-1 DOOR PANELD3213-3 DOOR PANELD3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
IN CONTROLLED COPY
NOTICE TO AMENDMENT
03.09.15
WORK ORDER
NO. 306410